

**Work Order ID 61795**

Friday, September 03, 2010 1:40:46 PM



Page 1

Item ID: D3936-041

Accept



Setup Start



Revision ID:

Item Name: Mapbox Assembly

Stop



Start Date: 9/3/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 9/14/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

*H*

Date: 10-9-03

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours.	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	-----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3936	A

100



Small Fab

Memo

0.00

Small Fab

1- Transfer drill holes and c'sink as per dwg (D3936-1/3-5)

2- Deburr

*ES-10/14* *(4)* *(PJO)*

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

*S.10.14**(4)* \_\_\_\_\_

114



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

*BL 10-10-14**(4)* \_\_\_\_\_

Hand Finishing

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3936-04) PAR #: W/A Fault Category: Sm. Fab NCR: Yes No DQA: 10 Date: 10/10/26  
 Resolution: Rework Disposition: Rework QA: N/C Closed: C/C Date: 10/10/26

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10-10-13	100	D3936-1 was not alodined before riveting R.C. (0A.)	AB Q9212	Alodine Dg rivet with soft white cne apply Alodine with a brush. Ensure Desolvator is rinsed	M/C 10/10/13	S 10/10/14	AB Q9212	10-10-13

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 9/14/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

115



QC3- Inspect Part Finish

0.00

  
9/10/10/18 4

QC

Quality Control

116



Memo

0.00

Small Fab

Small Fab

1- Assemble as per dwg (D3936-1/3/-5)

0.00

  
9/10/10/18 4  
PRO

117



QC5- Inspect part completeness to step on W/O

0.00

0.00

QC

Quality Control

  
9/10/10/17  
9/10/10/17

WO: 61795	WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10.10.13	116	MS 20426 AD 3-5 IS TOO LOW. CHANGE TO MS 20426 A 3-4.				10.10.13 dsl042		

Part No: D3936-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Cust Item ID:

Required Date: 9/14/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

120



Powdercoat

Powder Coating

Operation  
Description

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

M 112588

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

Set Up/  
Run Hours

0.00

10-10-19

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInspec.  
Stamp

0.00

130



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

10-10-19

A

4 D

140



Small Fab

Small Fab

Memo

0.00

0.00

INSTALL RUBBER CUSHION AND PLACARD AS PER DWG

Jg 10/21 Q

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 9/14/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



Packaging

Packaging

Identify as per dwg &amp; Stock Location:

0.00

PPP  
63190

20 10/10/25

4

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/10/25 G

10/10/25 J

MF  
10-10-25

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NOTE: Date & initial all entries

# Picklist Print

Friday, September 03, 2010 1:40:52 PM

Page 1  
2

Work Order ID: 61795



Parent Item: D3936-041



Parent Item Name: Mapbox Assembly

Start Date: 9/3/2010

Required Date: 9/14/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3936-1 		Manufactured	No			100	Each	0.0000	1	1		<i>E/B 10/10/21</i>	
Sides								<i>B61796</i>					
D3936-3 		Manufactured	No			100	Each	2.0000	1	1		<i>E/B 10/10/21</i>	
Bottom												<i>B62265 (2)</i>	
D3936-5 		Manufactured	No			100	Each	2.0000	1	1		<i>E/B 10/10/21</i>	
Divider												<i>B62266 (4x)</i>	
D3938-3 		Manufactured	No			140	Each	7.0000	1	1		<i>E/B 10/10/21</i>	
Placard													
D3941-40 		Purchased	No			140	Each	0.0000	1	1		<i>E/B 10/10/21</i>	
Rubber Cushion CUT (1x) 40.00" PER DWG												<i>B50200 (1)</i>	
												<i>B63061 (3)</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

Friday, September 03, 2010 1:40:52 PM

Work Order ID: 61795



Parent Item: D3936-041



Parent Item Name: Mapbox Assembly

Start Date: 9/3/2010

Required Date: 9/14/2010

Start Qty: 1.00

Required Qty: 1.00

D3941-12

Purchased

No

140

Each

0.0000

1

1

Rubber Cushion

CUT (1X) 12.00" PER DWG

MS20426AD3-4



RIVET

Purchased

No

100

Each

6,540.000

56

MS20426AD3-4



Rivet

Purchased

No

100

Each

14,844.00

8

5 too long  
10.10.13  
051 042

## Location

## Loc Qty

## Loc Code

ST316

6540

104374

2540

110398

4000

100

Each

14,844.00

8

## Location

## Loc Qty

## Loc Code

ST316

14844

4179

3006

4444

5678

4533

6160

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

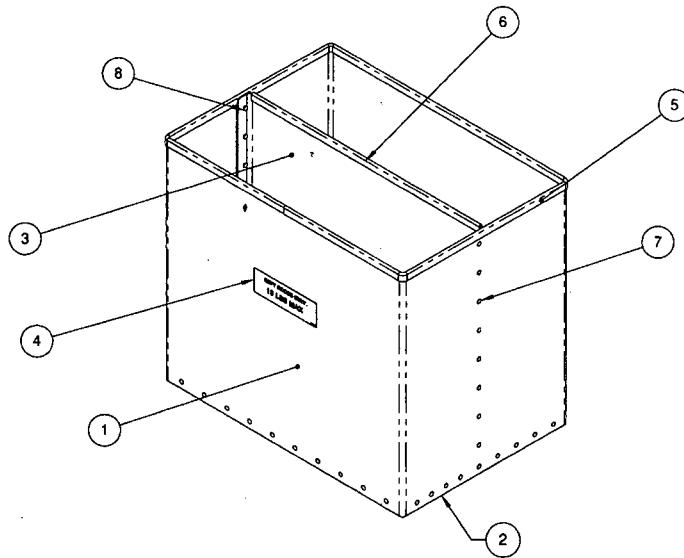
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	D3936-1	SIDES
2	1	D3936-3	BOTTOM
3	1	D3936-5	DIVIDER
4	1	D3938-3	PLACARD
5	1	D3941-40	RUBBER CUSHION
6	1	D3941-12	RUBBER CUSHION
7	56	MS20426AD3-4	RIVET
8	8	MS20426AD3-5	RIVET



**D3936-041 MAPBOX ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3936-041" AND B/N USING A WHITE FINE POINT PAINT MARKER
- 7) WEIGHT: 2.54 lbs

**ASSEMBLY INSTRUCTIONS**

1. BEND D3936-1/-3/-5 PARTS PER SHEETS 2-7.
2. POSITION D3936-5 DIVIDER IN PLACE INSIDE THE D3936-1 SIDES AND CLECO IN PLACE.
3. POSITION THE D3936-3 BOTTOM IN PLACE AGAINST THE D3936-5 DIVIDER AND INSIDE THE D3936-1 SIDES.
4. TRANSFER DRILL 10X Ø.098 (#40 DRILL) HOLES FROM THE D3936-3 BOTTOM TO THE D3936-5 DIVIDER. PLACE CLECO'S IN TRANSFER DRILLED HOLES TO MAINTAIN ALIGNMENT AS THEY ARE DRILLED.
5. TRANSFER DRILL 38X Ø.098 HOLES FROM D3936-1 SIDES TO D3936-3 BOTTOM. PLACE CLECO'S IN TRANSFER DRILLED HOLES TO MAINTAIN ALIGNMENT AS THEY ARE DRILLED.
6. REMOVE ALL CLECO'S AND COUNTERSINK 64X EXTERIOR HOLES Ø.179 X 100°. DEBURR ALL HOLES IN ALL PARTS.
7. REASSEMBLE PARTS USING CLECO'S IN EVERY THIRD HOLE TO MAINTAIN ALIGNMENT.
8. RIVET D3936-1 SIDE TO D3936-5 DIVIDER USING MS20426AD3 RIVETS. INSTALL MS20426AD3 RIVETS RANDOMLY THROUGHOUT ASSEMBLY SO THAT ALL PARTS ARE DRAWN TOGETHER EVENLY.
9. RIVET D3936-5 DIVIDER TO D3936-3 BOTTOM USING MS20426AD3 RIVETS. INSTALL MS20426AD3 RIVETS RANDOMLY THROUGHOUT ASSEMBLY SO THAT ALL PARTS ARE DRAWN TOGETHER EVENLY.
10. RIVET D3936-3 BOTTOM TO D3936-1 SIDE USING MS20426AD3 RIVETS. INSTALL MS20426AD3 RIVETS RANDOMLY THROUGHOUT ASSEMBLY SO THAT ALL PARTS ARE DRAWN TOGETHER EVENLY.
11. POWDER COAT ASSEMBLY PER NOTE 2.
12. TEST FIT RUBBER CUSHION TO TOP EDGE OF MAPBOX. TRIM AS REQUIRED FOR PROPER FIT.
13. REMOVE RUBBER CUSHION.
14. APPLY SMALL BEAD OF SILICONE/ADHESIVE TO TOP EDGE OF MAPBOX.
15. SLIDE RUBBER CUSHION OVER EDGE AND PRESS INTO SILICONE/ADHESIVE.
16. WIPE OFF ANY EXCESS SILICONE/ADHESIVE BEFORE IT DRIES/CURES.
17. APPLY D3938-3 PLACARD AS SHOWN.
18. ALLOW SEALANT/ADHESIVE TO CURE/DRY 24 HRS BEFORE SHIPPING PART.

**RELEASED**  
2009-08-28  
MJD

SHOP COPY  
RETURNED BY  
ENGINEERING  
UNCONTROLLED BY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 41795  
4

A	NEW ISSUE	09.07.08
REV.	BY DATE	
DESIGN	TP	DART AEROSPACE LTD
DRAWN	TP	HAWKESBURY, ONTARIO, CANADA
CHECKED	AS	DRAWING NO. REV. A
MFG. APPR.	TP	D3936 SHEET 1 OF 7
APPROVED	TP	TITLE SCALE
DE APPR.	TP	MAPBOX NTS
DATE	09.07.08	

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PL 10-9-03

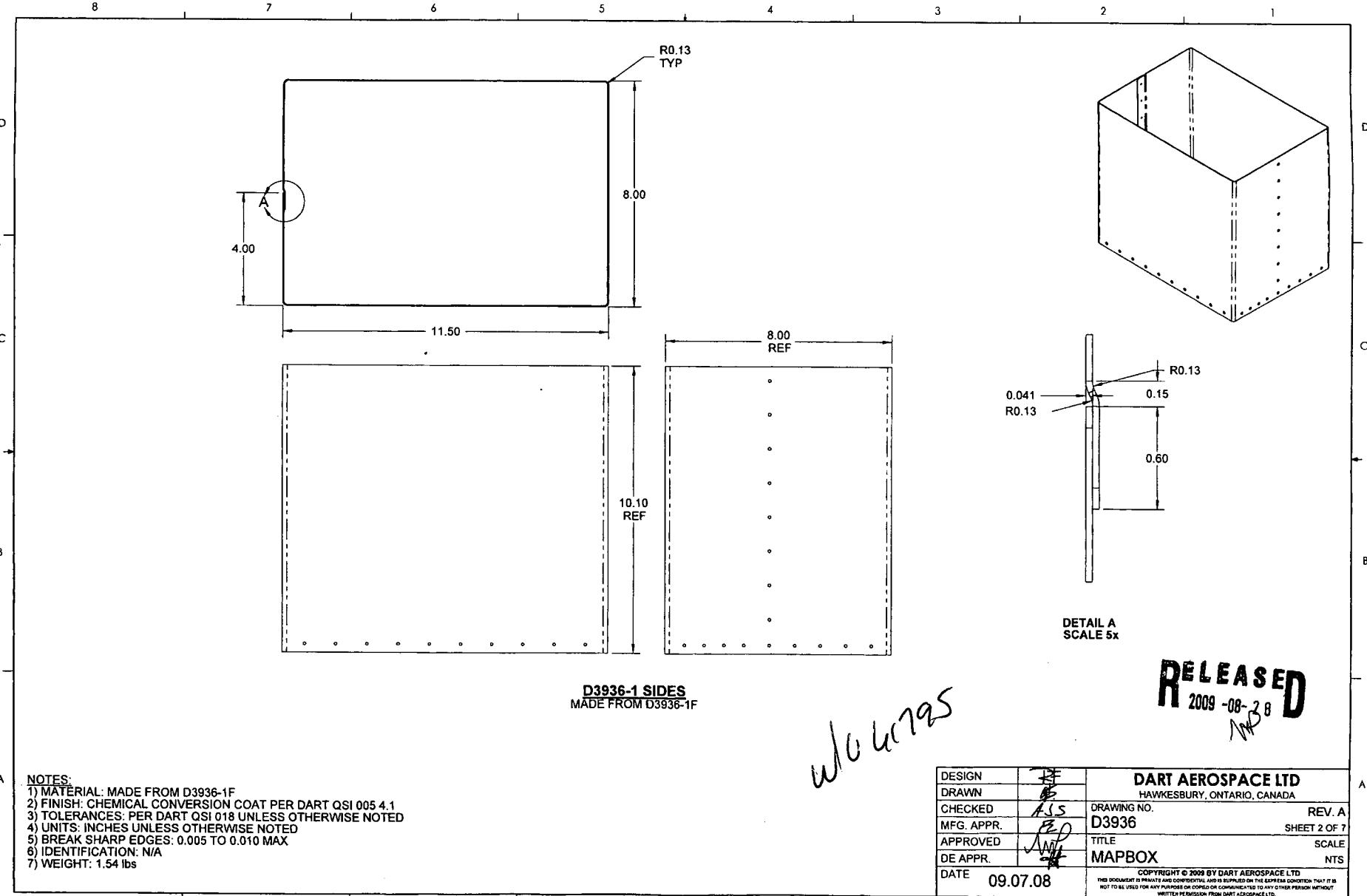
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NOTE: Date & initial all entries



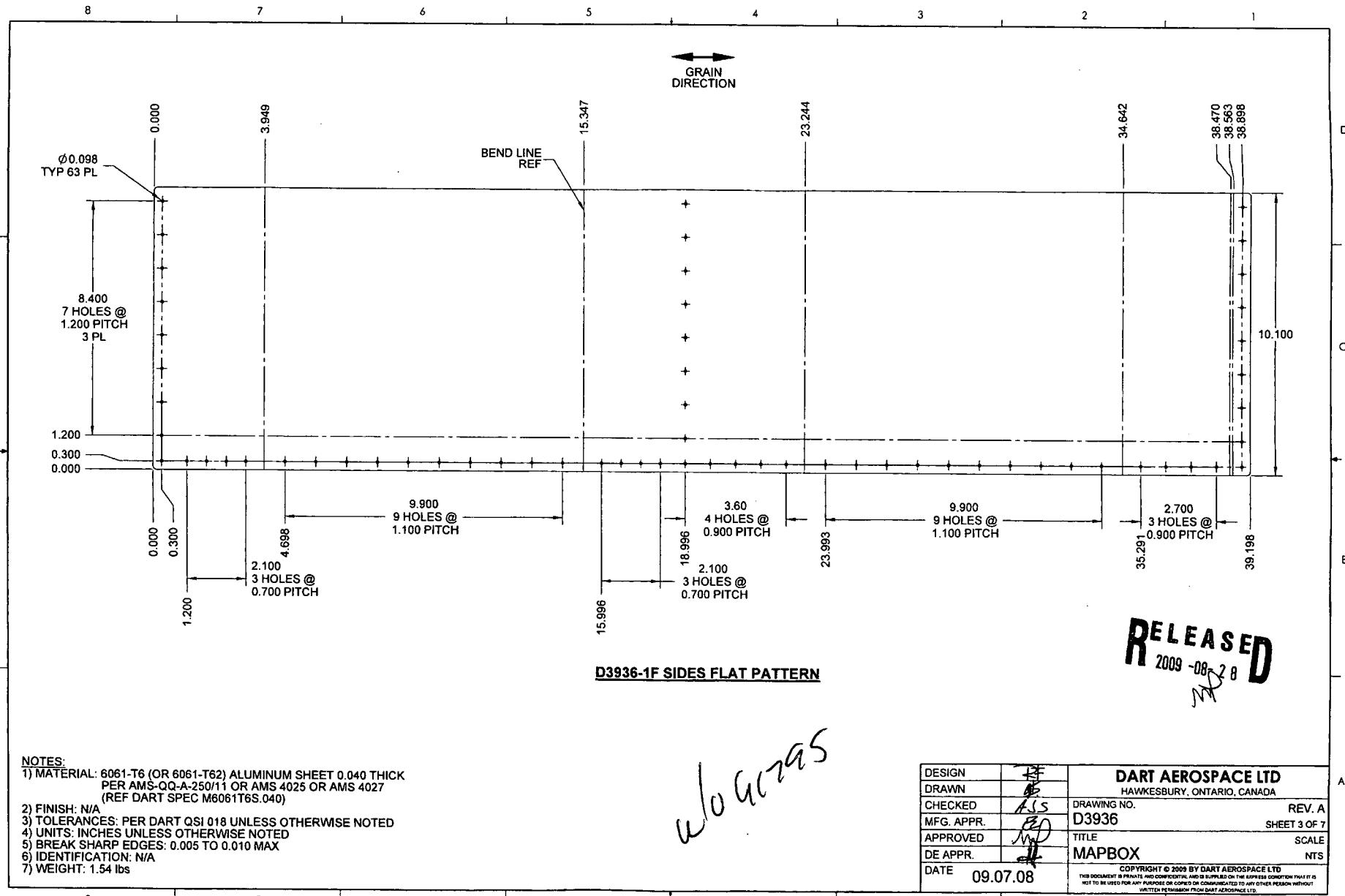
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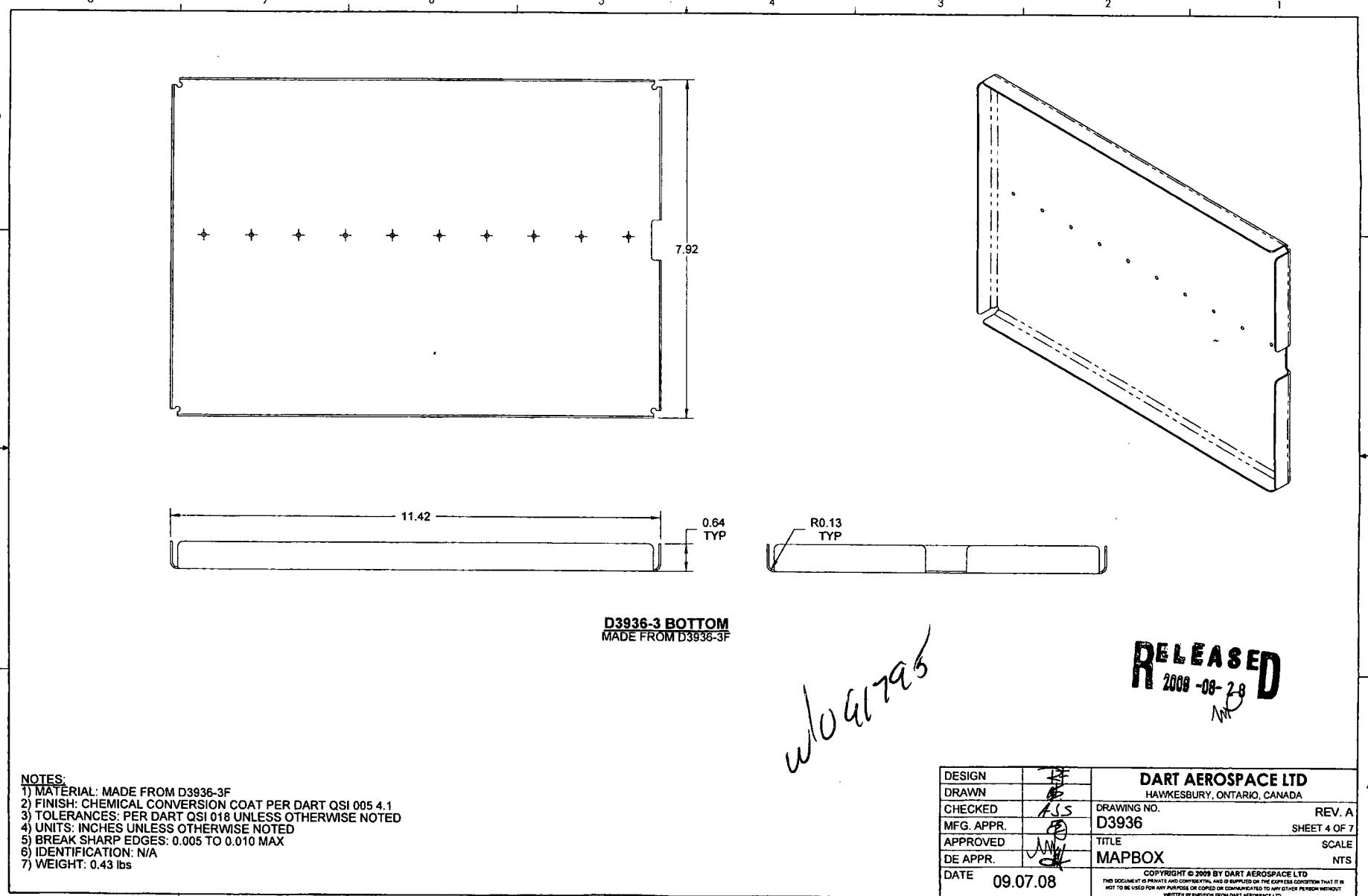
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	AS	DRAWING NO.
MFG. APPR.	EP	REV. A
APPROVED	JW	D3936
DE APPR.	WJ	SHEET 4 OF 7
DATE	09.07.08	SCALE
		NTS
		MAPBOX

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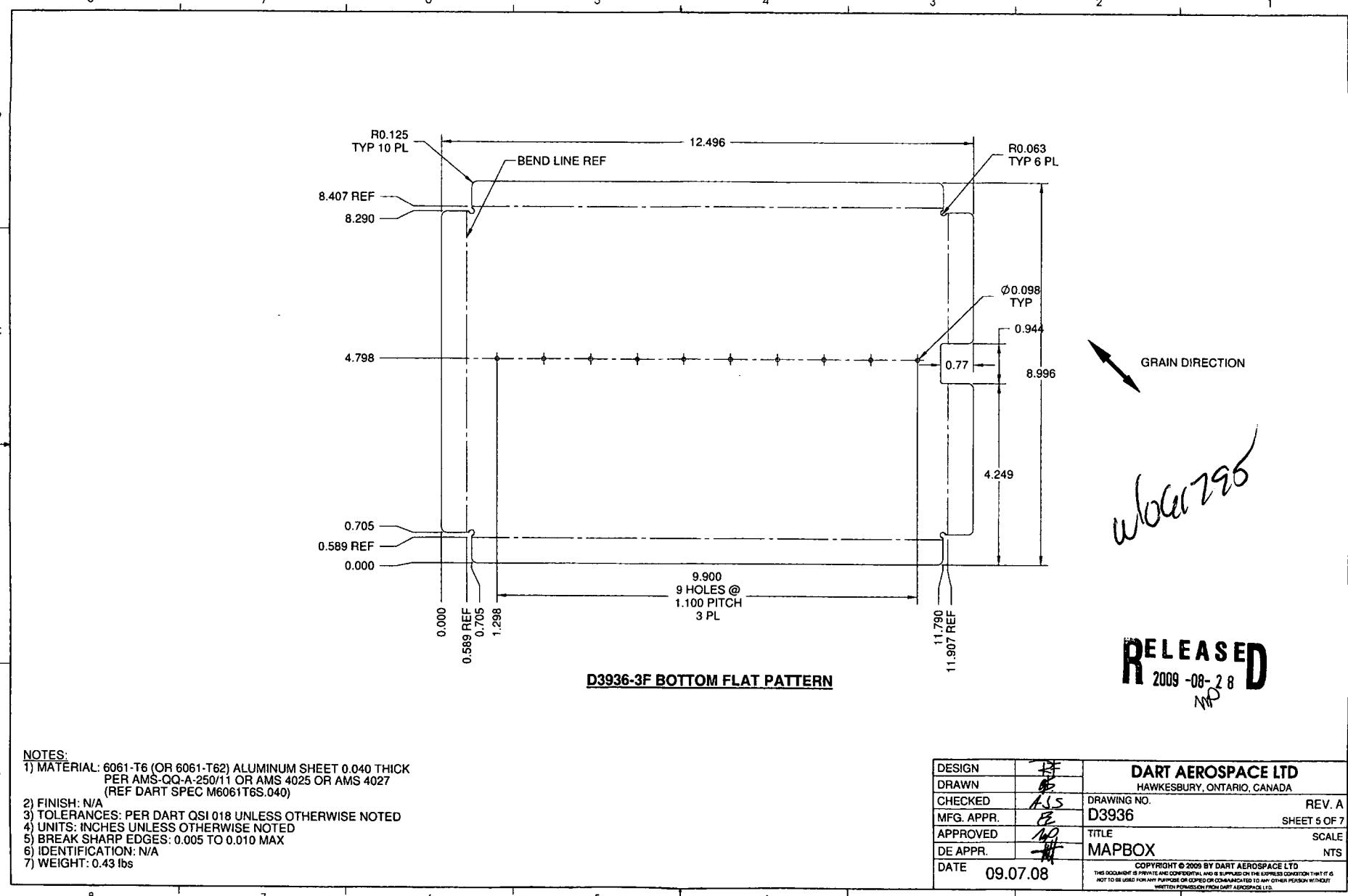
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CHECKED	AS	DRAWING NO.
MFG. APPR.	EB	REV. A
APPROVED	MO	D3936
DE APPR.	MM	SHEET 5 OF 7
DATE	09.07.08	TITLE
		MAPBOX
		SCALE
		NTS

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2009-08-28  
MP

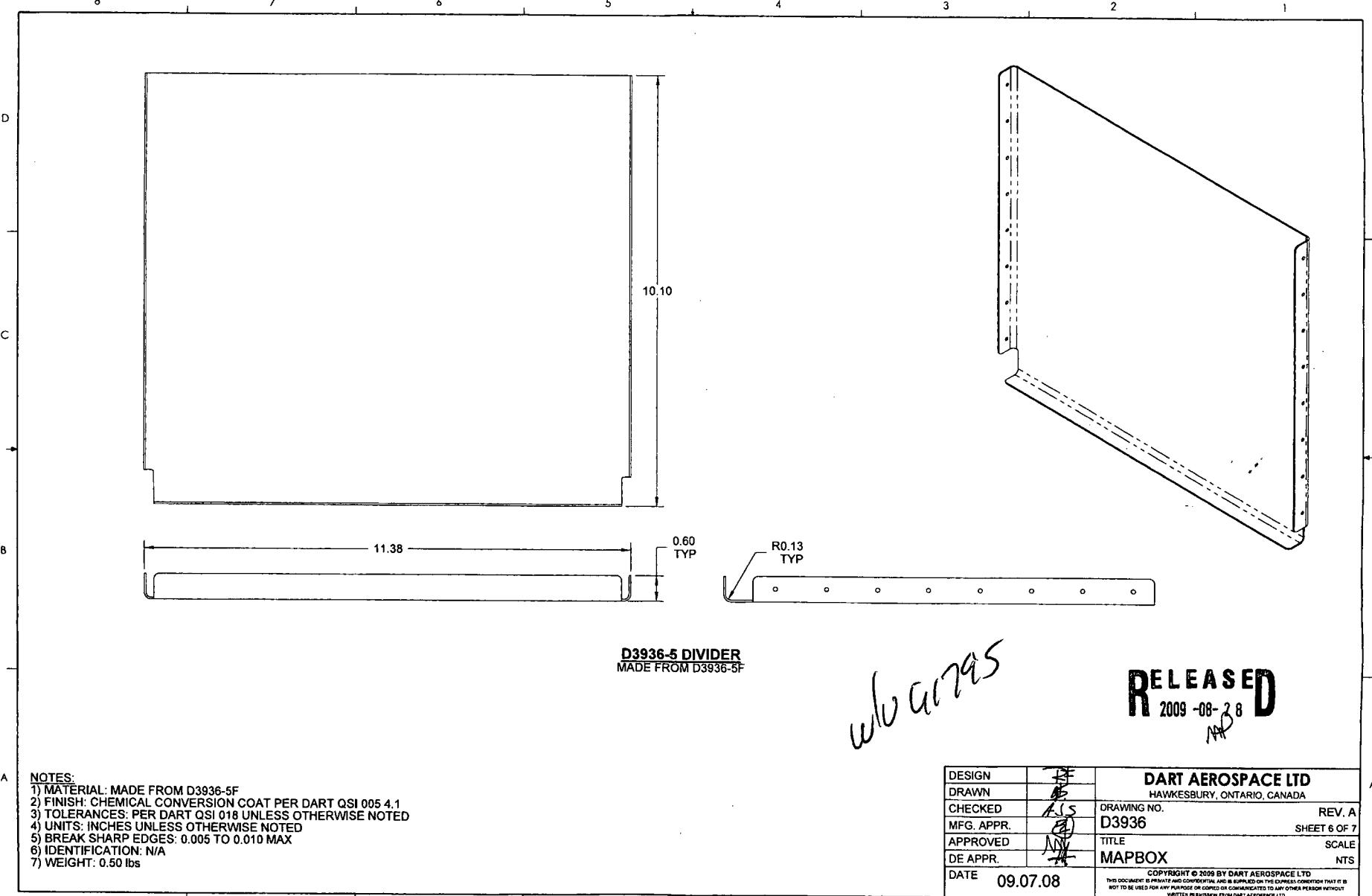
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